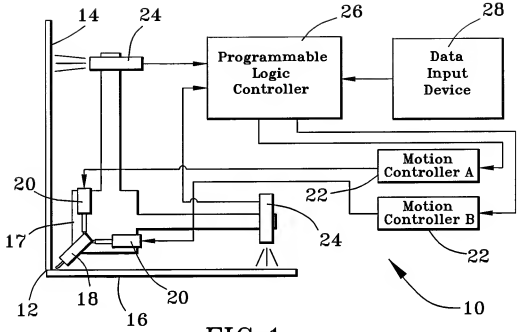

14
24
26
28
Programmable Logic Controller
Data Input Device
Motion Controller A
Motion Controller B
20
22
17
24
22
12
18
20
16
10

FIG.1

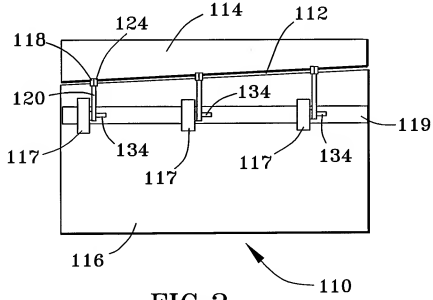
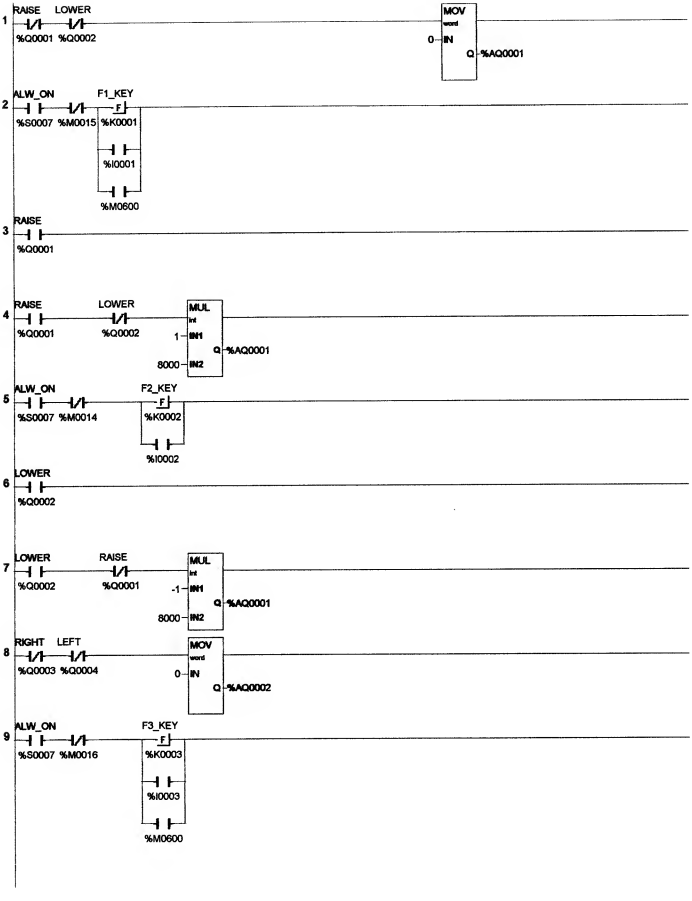
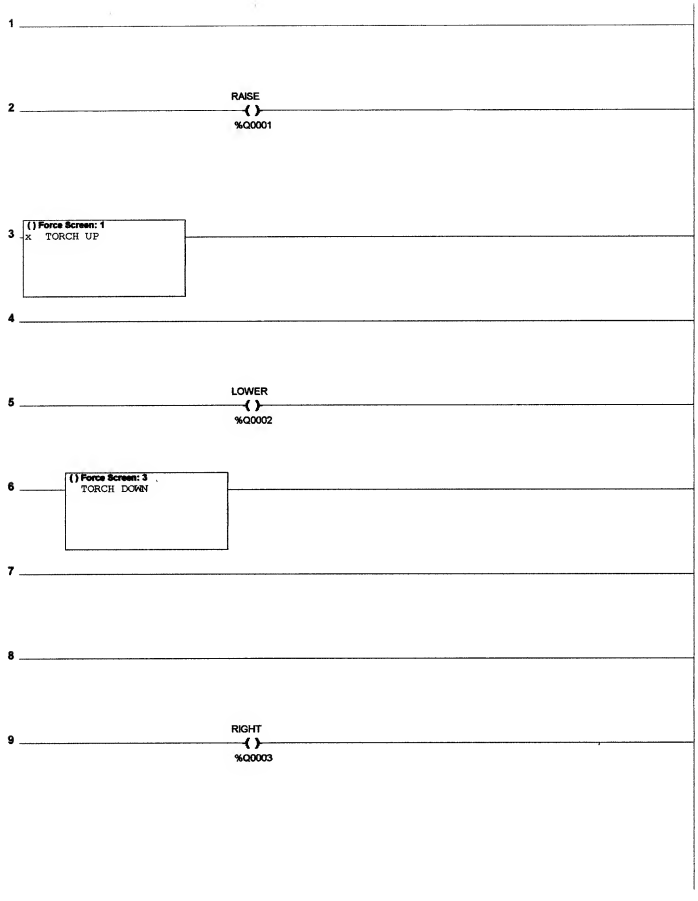
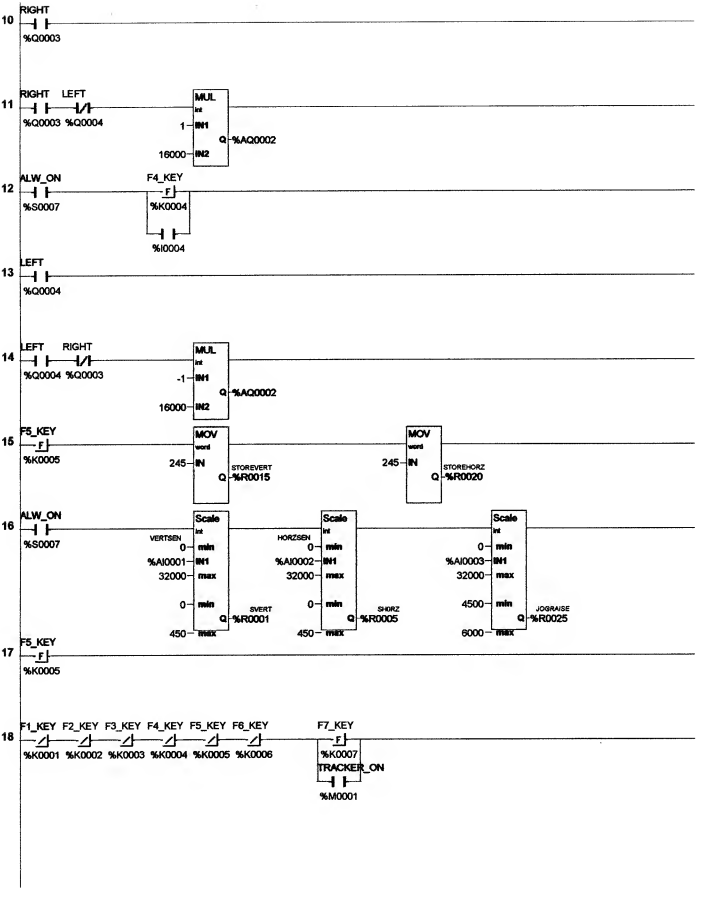
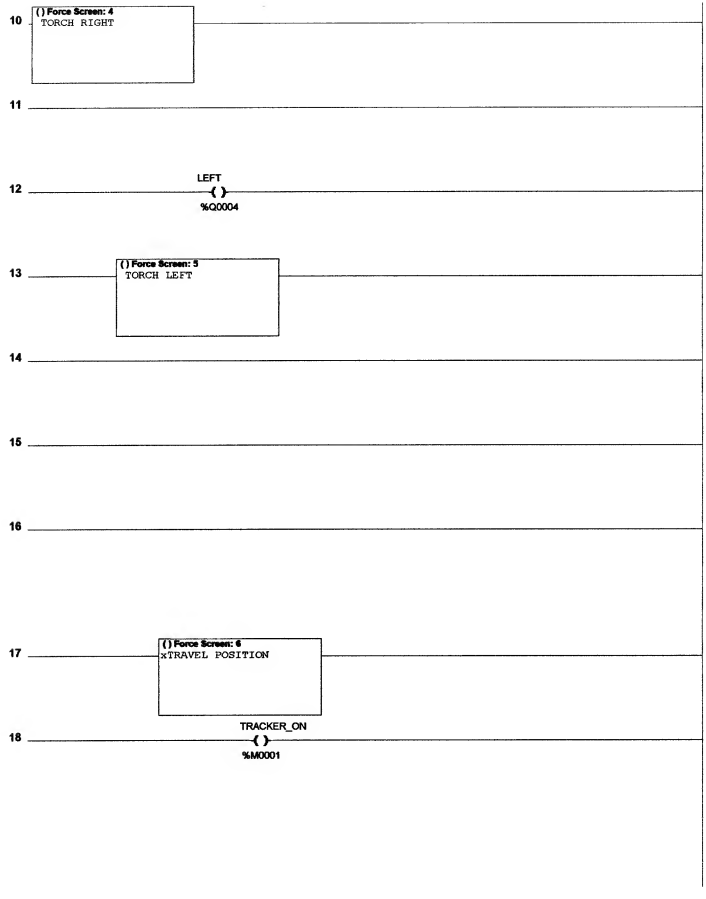

114
112
124
118
120
134
119
117
134
117
117
134
116
110

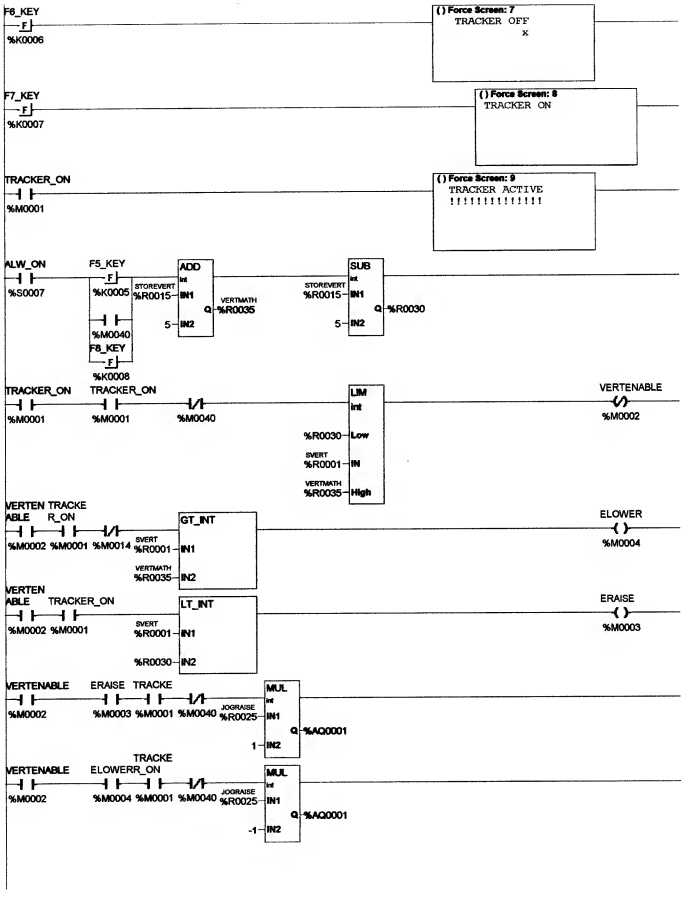
FIG.2


1
RAISE
LOWER
%Q0001
%Q0002
MOV
word
0
IN
Q
%AQ0001
2
ALW_ON
F1_KEY
F
%S0007
%M0015
%K0001
%I0001
%M0600
3
RAISE
%Q0001
4
RAISE
LOWER
%Q0001
%Q0002
MUL
int
1
IN1
Q
%AQ0001
8000
IN2
5
ALW_ON
F2_KEY
F
%S0007
%M0014
%K0002
%I0002
6
LOWER
%Q0002
7
LOWER
RAISE
%Q0002
%Q0001
MUL
int
-1
IN1
Q
%AQ0001
8000
IN2
8
RIGHT
LEFT
%Q0003
%Q0004
MOV
word
0
IN
Q
%AQ0002
9
ALW_ON
F3_KEY
F
%S0007
%M0016
%K0003
%I0003
%M0600


1
2
RAISE
( )
%Q0001
3
( ) Force Screen: 1
x TORCH UP
4
5
LOWER
( )
%Q0002
6
( ) Force Screen: 3
TORCH DOWN
7
8
9
RIGHT
( )
%Q0003


10
RIGHT
%Q0003
11
RIGHT
LEFT
%Q0003
%Q0004
MUL
int
1
IN1
16000
IN2
Q
%AQ0002
12
ALW_ON
%S0007
F4_KEY
F
%K0004
%I0004
13
LEFT
%Q0004
14
LEFT
RIGHT
%Q0004
%Q0003
MUL
int
-1
IN1
16000
IN2
Q
%AQ0002
15
F5_KEY
F
%K0005
MOV
word
245
IN
STOREVERT
Q
%R0015
MOV
word
245
IN
STOREHORZ
Q
%R0020
16
ALW_ON
%S0007
Scale
int
VERTSEN
0
min
%AI0001
IN1
32000
max
0
min
450
max
SVERT
Q
%R0001
Scale
int
HORZSEN
0
min
%AI0002
IN1
32000
max
0
min
450
max
SHORZ
Q
%R0005
Scale
int
0
min
%AI0003
IN1
32000
max
4500
min
6000
max
JOGRAISE
Q
%R0025
17
F5_KEY
F
%K0005
18
F1_KEY
F2_KEY
F3_KEY
F4_KEY
F5_KEY
F6_KEY
%K0001
%K0002
%K0003
%K0004
%K0005
%K0006
F7_KEY
F
%K0007
TRACKER_ON
%M0001


10
() Force Screen: 4
TORCH RIGHT
11
12
LEFT
( )
%Q0004
13
() Force Screen: 5
TORCH LEFT
14
15
16
17
() Force Screen: 6
xTRAVEL POSITION
18
TRACKER_ON
( )
%M0001


19
F6_KEY
F
%K0006
( ) Force Screen: 7
TRACKER OFF
x
20
F7_KEY
F
%K0007
( ) Force Screen: 8
TRACKER ON
21
TRACKER_ON
%M0001
( ) Force Screen: 9
TRACKER ACTIVE
!!!!!!!!!!!!!!!
22
ALW_ON
%S0007
F5_KEY
F
%K0005
%M0040
F8_KEY
F
%K0008
STOREVERT
%R0015
ADD
int
IN1
IN2
Q
VERTMATH
%R0035
5
SUB
int
STOREVERT
%R0015
IN1
IN2
Q
%R0030
5
23
TRACKER_ON
%M0001
TRACKER_ON
%M0001
%M0040
LIM
int
%R0030
Low
SVERT
%R0001
IN
VERTMATH
%R0035
High
VERTENABLE
%M0002
24
VERTENABLE
%M0002
TRACKER_ON
%M0001
%M0014
SVERT
%R0001
IN1
VERTMATH
%R0035
IN2
GT_INT
ELOWER
%M0004
25
VERTENABLE
%M0002
TRACKER_ON
%M0001
SVERT
%R0001
IN1
%R0030
IN2
LT_INT
ERAISE
%M0003
26
VERTENABLE
%M0002
ERAISE
%M0003
TRACKER
%M0001
%M0040
JOGRAISE
%R0025
MUL
int
IN1
IN2
Q
%AQ0001
1
27
VERTENABLE
%M0002
ELOWERR_ON
%M0004
TRACKER
%M0001
%M0040
JOGRAISE
%R0025
MUL
int
IN1
IN2
Q
%AQ0001
-1

19

20

21

22

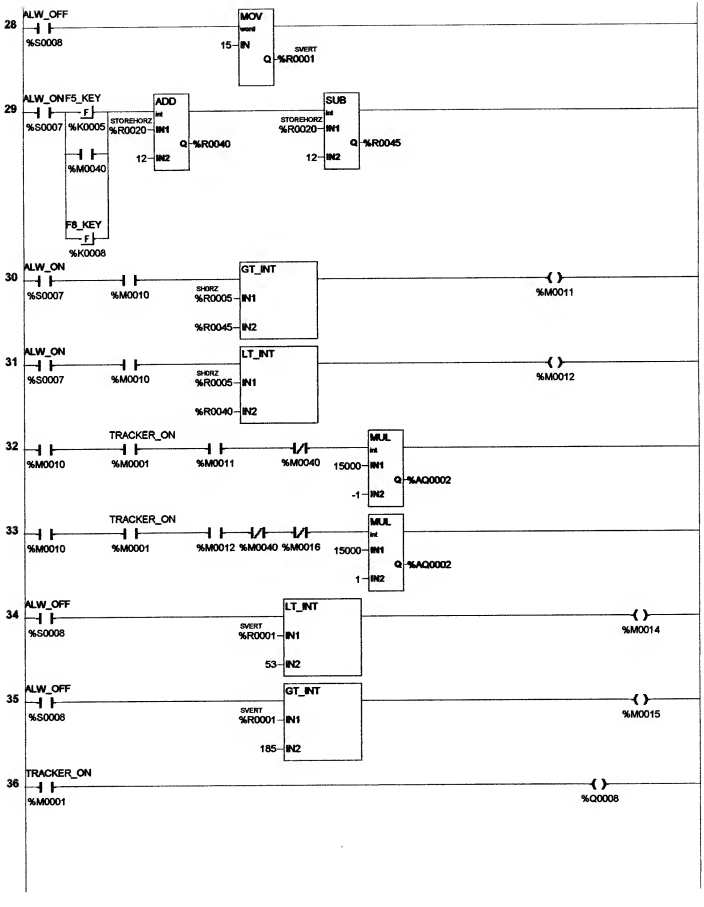
23

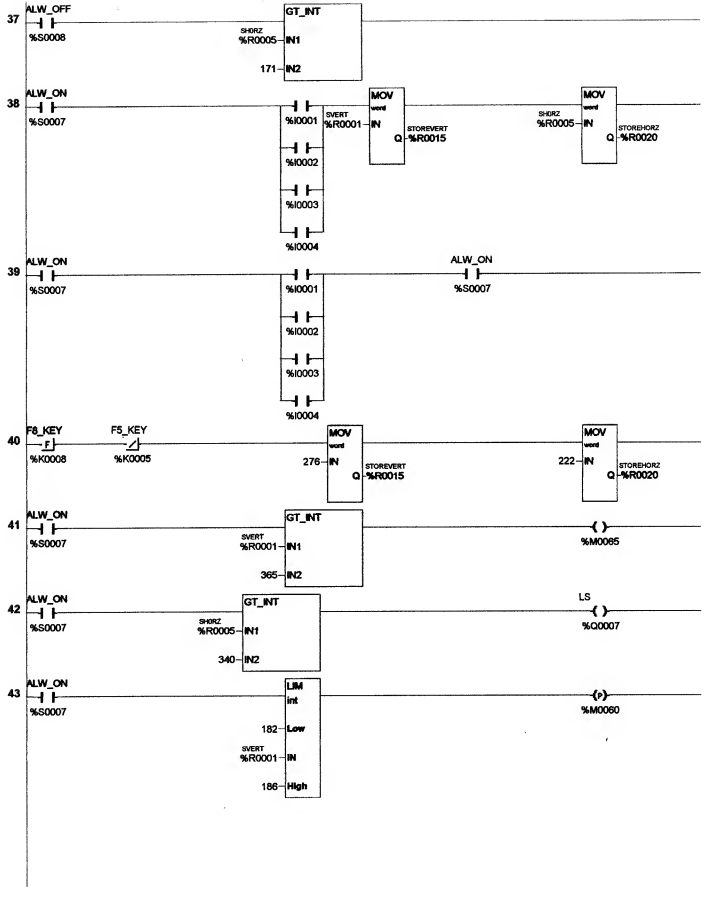
24

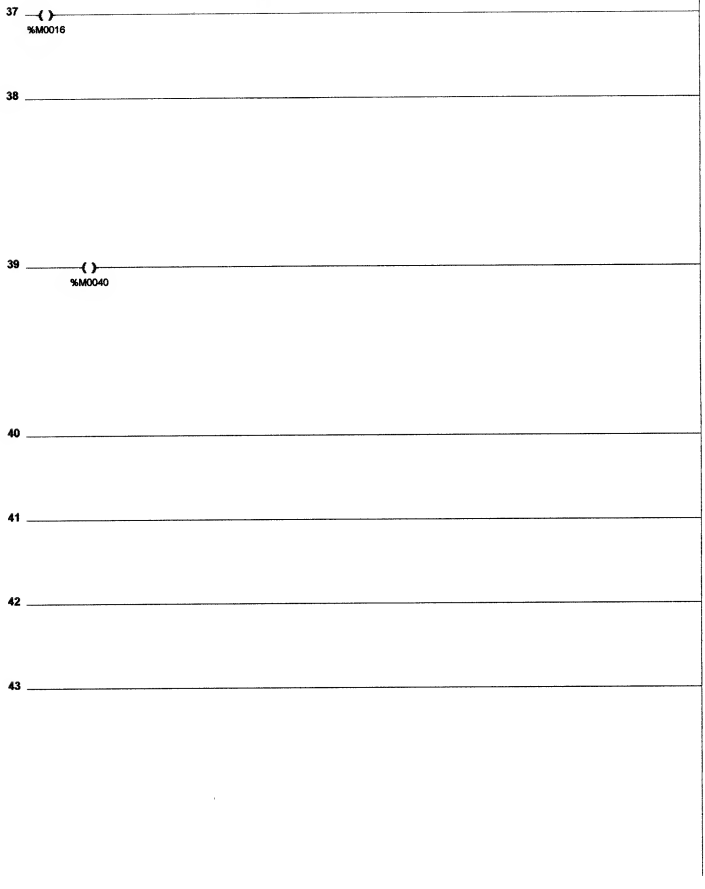
25

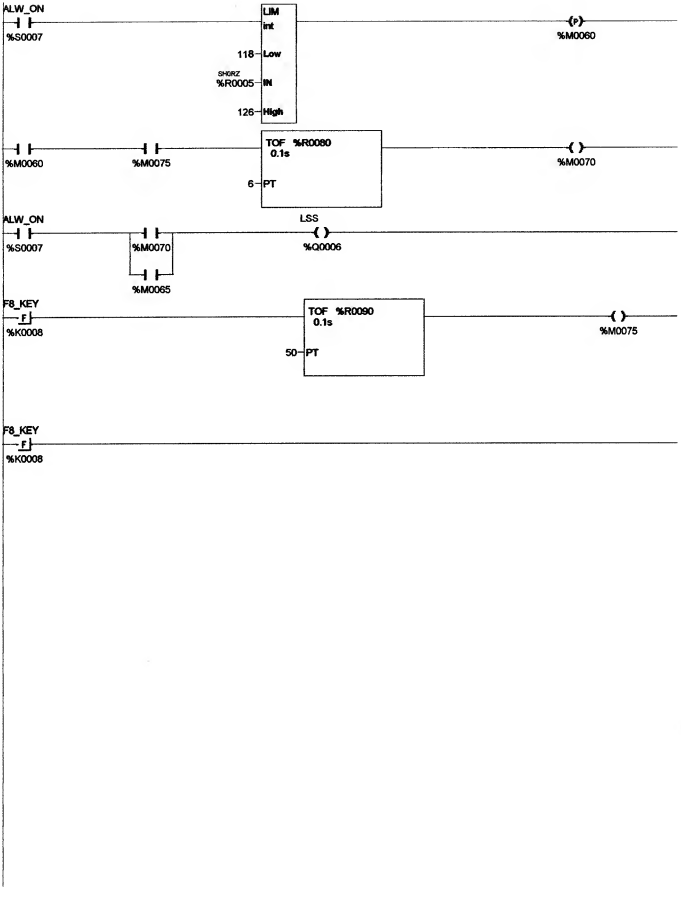
26

27


28
ALW_OFF
%S0008
MOV
word
15
IN
SVERT
Q
%R0001
29
ALW_ON
F5_KEY
%S0007
%K0005
STOREHORZ
%R0020
ADD
int
IN1
Q
%R0040
12
IN2
%M0040
F8_KEY
%K0008
STOREHORZ
%R0020
SUB
int
IN1
Q
%R0045
12
IN2
30
ALW_ON
%S0007
%M0010
GT_INT
SHORZ
%R0005
IN1
%R0045
IN2
%M0011
31
ALW_ON
%S0007
%M0010
LT_INT
SHORZ
%R0005
IN1
%R0040
IN2
%M0012
32
TRACKER_ON
%M0010
%M0001
%M0011
%M0040
MUL
int
15000
IN1
Q
%AQ0002
-1
IN2
33
TRACKER_ON
%M0010
%M0001
%M0012
%M0040
%M0016
MUL
int
15000
IN1
Q
%AQ0002
1
IN2
34
ALW_OFF
%S0008
LT_INT
SVERT
%R0001
IN1
53
IN2
%M0014
35
ALW_OFF
%S0008
GT_INT
SVERT
%R0001
IN1
185
IN2
%M0015
36
TRACKER_ON
%M0001
%Q0008


37
ALW_OFF
%S0008
GT_INT
SHORZ
%R0005
IN1
171
IN2
38
ALW_ON
%S0007
%I0001
%I0002
%I0003
%I0004
SVERT
%R0001
MOV
word
IN
Q
STOREVERT
%R0015
SHORZ
%R0005
STOREHORZ
%R0020
39
ALW_ON
%S0007
%I0001
%I0002
%I0003
%I0004
ALW_ON
%S0007
40
F8_KEY
F
%K0008
F5_KEY
%K0005
276
222
41
ALW_ON
%S0007
GT_INT
SVERT
%R0001
IN1
365
IN2
%M0085
42
ALW_ON
%S0007
GT_INT
SHORZ
%R0005
IN1
340
IN2
LS
%Q0007
43
ALW_ON
%S0007
LIM
int
182
Low
SVERT
%R0001
IN
186
High
%M0060

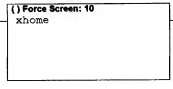

37
( )
%M0016
38
39
( )
%M0040
40
41
42
43


44
ALW_ON
%S0007
LIM
Int
118
Low
SHORZ
%R0005
IN
126
High
%M0060
45
%M0060
%M0075
TOF %R0080
0.1s
6
PT
%M0070
46
ALW_ON
%S0007
%M0070
%M0065
LSS
%Q0006
47
F8_KEY
F
%K0008
TOF %R0090
0.1s
50
PT
%M0075
48
F8_KEY
F
%K0008

44

45

46

47

48